

**\*85747\***

Page 1

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Cust Item ID:**

**Start Date:** 14/06/2012    **Start Qty:** 2.00    **\*2\***

**Required Date:** 28/06/2012      **Req'd Qty:** 2.00      **\*2\***

**Customer:**

**Reference:**

Approvals: \_\_\_\_\_ Process Plan: MLJ Date: 12/06/14 Tooling: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_/\_\_\_\_/\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Stop \*NR2\*

[illegible]

**Work Order ID 85747**

June-14-12 1:57:56 PM

**\*85747\***

Page 2

Item ID: D350-607-511

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Quick Release Basket Mounting Installation

Stop **\*NS2\***

Start Date: 14/06/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 28/06/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N): Date:

Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                               | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160                            |  | 0.00                 |         |        |              |               |               |                  |                |
| <b>*160*</b>                   | Packaging  |                      |         |        |              |               |               |                  |                |
| Packaging                      | Memo   | 0.00                 |         |        |              |               |               |                  |                |
| Packaging                      | Identify and pack for shipping as per PPP D350-607-511 |                      |         |        |              |               |               |                  |                |
|                                | Location: <i>P11 G12</i>                               |                      |         |        |              |               |               |                  |                |
| 170                            |  |                      |         |        |              |               |               |                  |                |
| <b>*170*</b>                   | QC21- Final Inspection - Work Order Release            | 0.00                 |         |        |              |               |               |                  |                |
| QC                             | Memo   | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |  |                      |         |        |              |               |               |                  |                |

*6/8/10 @**12/8/13**MLJ 12/08/10*

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

|  |   |  |                                      |                                    |  |                                      |                                    |                                    |  |                                  |  |                                    |                                   |  |                                    |                                    |                                |  |
|--|---|--|--------------------------------------|------------------------------------|--|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|-----------------------------------|--|------------------------------------|------------------------------------|--------------------------------|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Work Order Update <input type="checkbox"/> | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/>   | Crosstube <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Supplier <input type="checkbox"/> |  | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Other <input type="checkbox"/> |  |
| Skid-tube <input type="checkbox"/>                           | Crosstube <input type="checkbox"/>  | Prod. Eng. Coord. <input type="checkbox"/>   | Engineering <input type="checkbox"/> |                                    |  |                                      |                                    |                                    |  |                                  |  |                                    |                                   |  |                                    |                                    |                                |  |
| Machining <input type="checkbox"/>                           | Small Fab <input type="checkbox"/>  | Rec/Store/Packaging <input type="checkbox"/>   | Quality <input type="checkbox"/>     |                                    |  |                                      |                                    |                                    |  |                                  |  |                                    |                                   |  |                                    |                                    |                                |  |
| Thermoforming <input type="checkbox"/>                       | Finishing <input type="checkbox"/>  | Supplier <input type="checkbox"/>  |                                      |                                    |  |                                      |                                    |                                    |  |                                  |  |                                    |                                   |  |                                    |                                    |                                |  |
| Large Fab <input type="checkbox"/>                           | Composite <input type="checkbox"/>  | Other <input type="checkbox"/>   |                                      |                                    |  |                                      |                                    |                                    |  |                                  |  |                                    |                                   |  |                                    |                                    |                                |  |

| Root Cause    | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data      |      |      |     |   |                   |                    |             |              |              |
| Equip/Tooling |      |      |     |   |                   |                    |             |              |              |
| Operator      |      |      |     |   |                   |                    |             |              |              |
| Material      |      |      |     |   |                   |                    |             |              |              |
| Offset/Setup  |      |      |     |   |                   |                    |             |              |              |
| Other         |      |      |     |   |                   |                    |             |              |              |
| Process       |      |      |     |   |                   |                    |             |              |              |
| Supplier      |      |      |     |   |                   |                    |             |              |              |
| Training      |      |      |     |   |                   |                    |             |              |              |
| Unauthorized  |      |      |     |   |                   |                    |             |              |              |

**FAULT CATEGORY**

| Landing Gear  | Hardware                                 | General  |
|---|--|--|
| <input type="checkbox"/> Bending Passes Below Min     | <input type="checkbox"/> Breaking        | <input type="checkbox"/> Burrs                           |
| <input type="checkbox"/> Centre Not Concentric to O/S | <input type="checkbox"/> Missing         | <input type="checkbox"/> Contamination                   |
| <input type="checkbox"/> Cracks                       | <input type="checkbox"/> Size/Length     | <input type="checkbox"/> Cut Too Short                   |
| <input type="checkbox"/> Crushed/Crimp at Bending     | <input type="checkbox"/> Spinning        | <input type="checkbox"/> Documentation/Data              |
| <input type="checkbox"/> Inspection Strip in Tube     | <input type="checkbox"/> Threading       | <input type="checkbox"/> Finish                          |
| <input type="checkbox"/> Other                        | <input type="checkbox"/> Wrong           | <input type="checkbox"/> Inspection Incomplete           |
| <input type="checkbox"/> Positioned Wrong             |  | <input type="checkbox"/> Inspection Unqualified          |
| <input type="checkbox"/> Ripples on Inner Bend        | <b>Drill Holes</b>                       | <input type="checkbox"/> Instructions Incomplete/Unclear |
| <input type="checkbox"/> Torque Waves in Extrusion    | <input type="checkbox"/> Misaligned      | <input type="checkbox"/> Jigs/Fixtures/Tooling           |
| <input type="checkbox"/> Turning Sequence             | <input type="checkbox"/> Ovalized        | <input type="checkbox"/> Kit Incorrect                   |
| <input type="checkbox"/> Wave/Twist in Tube           | <input type="checkbox"/> Over/Undersized | <input type="checkbox"/> Kit Missing                     |
|   | <input type="checkbox"/> Too Many        |  |
|   |  | <input type="checkbox"/> Maintenance                     |
|   |  | <input type="checkbox"/> Mislabeled                      |
|   |  | <input type="checkbox"/> Off-Set                         |
|   |  | <input type="checkbox"/> Orientation Misread             |
|   |  | <input type="checkbox"/> Out of Calibration              |
|   |  | <input type="checkbox"/> Out of Sequence                 |
|   |  | <input type="checkbox"/> Outside Dimensions              |
|   |  | <input type="checkbox"/> Over/Under tolerance            |
|   |  | <input type="checkbox"/> Part Lost                       |
|   |  | <input type="checkbox"/> Part Moved                      |
|   |  | <input type="checkbox"/> Raw Material                    |
|   |  | <input type="checkbox"/> Set-up                          |
|   |  | <input type="checkbox"/> Supplier                        |
|   |  | <input type="checkbox"/> Temperature/Cure                |
|   |  | <input type="checkbox"/> Weld                            |
|   |  | <input type="checkbox"/> Wrong Stock Pulled              |
|   |  | <input type="checkbox"/> Other                           |

# Picklist Print

June-14-12 1:57:59 PM

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Work Order ID: 85747

**\*85747\***

Parent Item: D350-607-511

**\*D350-607-511\***

Parent Item Name: Quick Release Basket Mounting Installation

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-06-28 JLM VERIFIED BY: LL

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D3910-3

Manufactured

No

140

Each

20.0000

4

8

\*\*

B85694 SP

**\*D3910-3\***

Crosstube Lug

Location

Loc Qty

Loc Code

st507

20

81574

20

D3984

Manufactured

No

140

f

237.4840

2

4

\*\*

**\*D3984\***

Rubber Extrusion, Crosstube

Location

Loc Qty

Loc Code

ST080

237.484

53707

237.484

CUT (8) AT 3.00" LONG

D4148-041

Manufactured

No

140

Each

1.0000

1

2

\*\*

**\*D4148-041\***

Crosstube Lug Assembly, Fwd

Location

Loc Qty

Loc Code

ST468

1

84191

1

D4149-041

Manufactured

No

140

Each

1.0000

1

2

\*\*

**\*D4149-041\***

Crosstube Lug Assembly, Aft

Location

Loc Qty

Loc Code

ST468

1

82966

1

# Picklist Print

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Work Order ID: 85747

**\*85747\***

Parent Item: D350-607-511

**\*D350-607-511\***

Parent Item Name: Quick Release Basket Mounting Installation

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 2.00

Required Qty: 2.00

AN4-14A

Purchased

No

140

Each

244.0000

16

32

\*\*

*31*  
*M122141 SD*

**\*AN4-14A\***

Bolt

## Location

## Loc Qty

## Loc Code

357

100

121349

100

ST357

144

120187

13

120769

1

121068

17

121444

100

121708

13

MS21042L4

Purchased

No

140

Each

3,157.0000

16

32

\*\*

*SD*

**\*MS21042L4\***

Nut

## Location

## Loc Qty

## Loc Code

ST300

3157

119075

116

121011

232

121444

2509

121652

300

*32*

NAS1149F0432P

Purchased

No

140

Each

636.0000

32

64

\*\*

*M122151 12/8/9 SD*

**\*NAS1149F0432P\***

Washer

## Location

## Loc Qty

## Loc Code

ST275

636

121350

636



NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

|  |   |   |                                      |                                    |  |                                      |                                    |                                    |  |                                  |  |                                    |                                   |  |                                    |                                    |                                |  |
|--|---|---|--------------------------------------|------------------------------------|--|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|-----------------------------------|--|------------------------------------|------------------------------------|--------------------------------|--|
| Work Order: _____<br><br>Part No. _____<br><br>NCR No. _____ | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/><br>Work Order Update <input type="checkbox"/> | <b>AGAINST DEPARTMENT/PROCESS</b><br><br><table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/>   | Crosstube <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Supplier <input type="checkbox"/> |  | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Other <input type="checkbox"/> |  |
| Skid-tube <input type="checkbox"/>                           | Crosstube <input type="checkbox"/>  | Prod. Eng. Coord. <input type="checkbox"/>  | Engineering <input type="checkbox"/> |                                    |  |                                      |                                    |                                    |  |                                  |  |                                    |                                   |  |                                    |                                    |                                |  |
| Machining <input type="checkbox"/>                           | Small Fab <input type="checkbox"/>  | Rec/Store/Packaging <input type="checkbox"/>  | Quality <input type="checkbox"/>     |                                    |  |                                      |                                    |                                    |  |                                  |  |                                    |                                   |  |                                    |                                    |                                |  |
| Thermoforming <input type="checkbox"/>                       | Finishing <input type="checkbox"/>  | Supplier <input type="checkbox"/>   |                                      |                                    |  |                                      |                                    |                                    |  |                                  |  |                                    |                                   |  |                                    |                                    |                                |  |
| Large Fab <input type="checkbox"/>                           | Composite <input type="checkbox"/>  | Other <input type="checkbox"/>  |                                      |                                    |  |                                      |                                    |                                    |  |                                  |  |                                    |                                   |  |                                    |                                    |                                |  |

| Root Cause                             | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|--|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data <input type="checkbox"/>      |      |      |     |   |                   |                    |             |              |              |
| Equip/Tooling <input type="checkbox"/> |      |      |     |   |                   |                    |             |              |              |
| Operator <input type="checkbox"/>      |      |      |     |   |                   |                    |             |              |              |
| Material <input type="checkbox"/>      |      |      |     |   |                   |                    |             |              |              |
| Offset/Setup <input type="checkbox"/>  |      |      |     |   |                   |                    |             |              |              |
| Other <input type="checkbox"/>         |      |      |     |   |                   |                    |             |              |              |
| Process <input type="checkbox"/>       |      |      |     |   |                   |                    |             |              |              |
| Supplier <input type="checkbox"/>      |      |      |     |   |                   |                    |             |              |              |
| Training <input type="checkbox"/>      |      |      |     |   |                   |                    |             |              |              |
| Unauthorized <input type="checkbox"/>  |      |      |     |   |                   |                    |             |              |              |

### FAULT CATEGORY

|   |  |   |   |
|---|--|---|---|
| <b>Landing Gear</b><br><input type="checkbox"/> Bending Passes Below Min<br><input type="checkbox"/> Centre Not Concentric to O/S<br><input type="checkbox"/> Cracks<br><input type="checkbox"/> Crushed/Crimp at Bending<br><input type="checkbox"/> Inspection Strip in Tube<br><input type="checkbox"/> Other<br><input type="checkbox"/> Positioned Wrong<br><input type="checkbox"/> Ripples on Inner Bend<br><input type="checkbox"/> Torque Waves in Extrusion<br><input type="checkbox"/> Turning Sequence<br><input type="checkbox"/> Wave/Twist in Tube | <b>Hardware</b><br><input type="checkbox"/> Breaking<br><input type="checkbox"/> Missing<br><input type="checkbox"/> Size/Length<br><input type="checkbox"/> Spinning<br><input type="checkbox"/> Threading<br><input type="checkbox"/> Wrong<br><br><b>Drill Holes</b><br><input type="checkbox"/> Misaligned<br><input type="checkbox"/> Ovalized<br><input type="checkbox"/> Over/Undersized<br><input type="checkbox"/> Too Many | <b>General</b><br><input type="checkbox"/> Burrs<br><input type="checkbox"/> Contamination<br><input type="checkbox"/> Cut Too Short<br><input type="checkbox"/> Documentation/Data<br><input type="checkbox"/> Finish<br><input type="checkbox"/> Inspection Incomplete<br><input type="checkbox"/> Inspection Unqualified<br><input type="checkbox"/> Instructions Incomplete/Unclear<br><input type="checkbox"/> Jigs/Fixtures/Tooling<br><input type="checkbox"/> Kit Incorrect<br><input type="checkbox"/> Kit Missing | <b>Maintenance</b><br><input type="checkbox"/> Mislabeled<br><input type="checkbox"/> Off-Set<br><input type="checkbox"/> Orientation Misread<br><input type="checkbox"/> Out of Calibration<br><input type="checkbox"/> Out of Sequence<br><input type="checkbox"/> Outside Dimensions<br><input type="checkbox"/> Over/Under tolerance<br><input type="checkbox"/> Part Lost<br><input type="checkbox"/> Part Moved<br><input type="checkbox"/> Raw Material<br><br><input type="checkbox"/> Set-up<br><input type="checkbox"/> Supplier<br><input type="checkbox"/> Temperature/Cure<br><input type="checkbox"/> Weld<br><input type="checkbox"/> Wrong Stock Pulled<br><input type="checkbox"/> Other |
|---|--|---|---|